

**Work Order ID 52469**

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September 25, 2009 11:05:48 AM

Item ID: D3684-045

Reference: NCR09-084 / RA109098

Revision ID: C

Item Name: LEG ASSEMBLY

Start Date: 09/25/09

Start Qty: 1.00

Cust Item ID:

Required Date: 09/30/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan: WDate: 09-09-25

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: /Date: 09-09-25

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

**Hours**

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3684	Rev C
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100	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00				<u>1</u>			<u>10-05-25</u>
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Quality Control

Memo D3684-045 original B44524, from RA109098

110	Small Fab		0.00	0.00				<u>1</u>	<u>2</u>		
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Small Fab

Memo Remove &amp; replace the D3688-5 stud (original B44685) and scrap &amp; destroy.

Pick new D3688-5 stud for re-install per dwg D3684-045.

SB 09/09/28

120	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00				<u>1</u>	<u>4</u>		
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Quality Control

Memo Inspect work to dwg.

130	Packaging	Identify as per dwg & Stock Location: _____	0.00	0.00				<u>9/9/08</u>		<u>WSP</u>	
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Packaging

Memo Return to stock with the new batch #.

Location: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Hours

Sequence ID	Work Center ID	Operation Description	Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							
140	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
Quality Control											
Memo											

09/09/29 *MF*

09-09-29

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[illegible]

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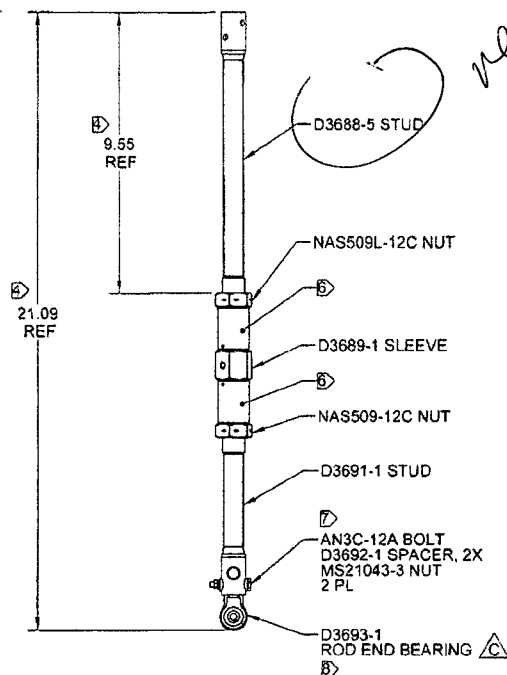
**Required Date:** 09/30/09

**Required Qty: 1.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3688-5RevC		Manufactured	No			110	Each	0.0000	1.0000			
					B 50933		<del>1</del>					
STUD									8	1		

5609(09/28

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-045 INBOARD LEG ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT



**REFERENCE ONLY**

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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